

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010659**Date Inspected:** 30-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, An Qin Xiang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10, East Tower, Strut.

SMAW welding of weld joint ED1-STSA3-2-89M-2-54; located on Bay 10, East Tower. Welders are identified as 067904; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4113-1.

Bay 11, South Tower, Strut.

SMAW welding of weld joint SD1-STSA3-1-89M-1-11B, 9B, 25A; located on Bay 11, South Tower. Welders are identified as 040656, 046704; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3212-TC-U5B-1.

Bay 11, East Tower, Lift 4, DE Corner.

SMAW Repair welding of weld joint ESTL4-2L/L-1B (CWR # T-CWR471); located on Bay 11, East tower. Welders are identified as 049099, 040733; ZPMC Quality Control Inspector (QC) is identified as An Qin Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-1G(1F)-REPAIR-1.

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Bay 11, East Tower, Lift 4, CD Corner.

SMAW Repair welding of weld joint ESTL4-2B/L-1B (WRR # T-WR2748); located on Bay 11, East tower. Welders are identified as 047470; ZPMC Quality Control Inspector (QC) is identified as An Qin Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-2G(2F)-REPAIR-1.

Bay 11, West Tower, Lift 4, Skin to Diaphragm, 119M elevation .

SMAW welding of weld joint WSTL4-2C/L-67, 66, 148, 147; located on Bay 11, West tower. Welders are identified as 202821; ZPMC Quality Control Inspector (QC) is identified as Liu Xiaozhong. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4332-TC-P5-F.

Bay 11, East Tower, Interior Corner Splice Sub Assembly.

FCAW Repair welding of weld joint ESD1-SPSA4-24-1A; located on Bay 11, East Tower. Welders are identified as 040723; ZPMC Quality Control Inspector (QC) is identified as Xu Le Feng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1) WPS-345-SMAW-2G(2F)-REPAIR.

This QA Inspector carried out NDE on following

Bay 11, East Tower, Lift 4, D/E Corner Seam.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as ESTL4-2B/L-61A/B (127M & 131M Double Diaphragm area).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
